

303 625

Work Order ID 70690



Page 1

Monday, June 13, 2011 1:33:19 PM

Item ID: D3873-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 6/13/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan: 11Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3873

B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA806 & DWG D3873 ,

FOLIO REV: N/ADWG REV: 13

2-DEBURR AS REQUIRED

SD 11/6/28

63

φ

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SD

11/6/28

63

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70690

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Page 2

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Start Date: 6/13/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

20 11-6-29

63

130

Identify as per dwg & Stock Location: ST 88

0.00



Packaging

Memo

0.00

Packaging

JB 63 11/06/29

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/29

11-06-29
63

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 1:33:25 PM

Page 1

Work Order ID: 70690

Parent Item: D3873-1

Parent Item Name: Bushing



Start Date: 6/13/2011

Required Date: 6/20/2011

Start Qty: 60.00

Required Qty: 60.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625 		Purchased	No			100	f	12.9800	0.06	3.789474			
303 Round Bar 0.625"													

Location

MAT028

110167
15267

Loc Qty

12.98
12.08
0.9

Loc Code

2.88
1.9

SD 11/6/28

18 inches

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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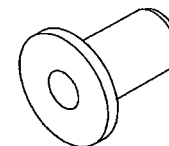
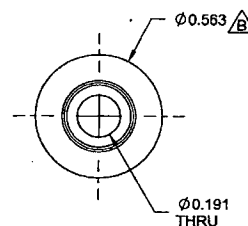
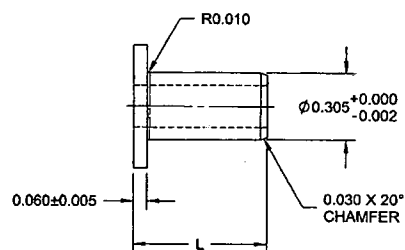
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D3873-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.01

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70696

11-06-13

RELEASED
2010-09-15

B	Ø0.563 WAS Ø0.63 (C3-1, TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	CP	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3873	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BUSHING	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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